

**Work Order ID 55063**

January 5, 2010 2:38:45 PM



Page 1

Item ID: D2858-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2858	Rev B

100		0.00							
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BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 6.02" □Note: 1 Blank Makes 3 Parts

mw= 10/01/12

4

110		0.00							
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HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2858-2□2-Deburr

mw= 10/01/13

12

0

120		0.00							
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QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mw= 10/01/13

12

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






**NOTE:** Date & initial all entries



# Work Order ID 55063




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Page 2

Item ID: D2858-2 Accept  Setup Start   
Revision ID: Stop   
Item Name: Hinge Bracket  
Start Date: 05/01/2010 Start Qty: 12.00  Cust Item ID:  
Required Date: 15/01/2010 Req'd Qty: 12.00  Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	H.A 10/01/13			12	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	JL 10/01/14			(X12)	0		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M1113170 Memo START TIME: 7:30 AM 8:00 AM FINISH TIME	0.00  0.00	=> JL 10/01/19			(X12)	0		
		OVEN TEMPERATURE: 320°F							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 55063**

January 5, 2010 2:38:45 PM

Page 3

Item ID: D2858-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-01-19

(12) 0

170

Identify as per dwg &amp; Stock Location: 21

0.00



Packaging

Memo

0.00

Packaging

10-1-19 (12x) 0

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/19  
ME 10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 2:38:50 PM

Work Order ID: 55063



Parent Item: D2858-2



Parent Item Name: Hinge Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	66.3728	2.1259			



6061-T6 Bar 1.50 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

66.3728

107461

11.84

110936

54.5328

2.1259

MAT  
6/01/12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>55063</b>
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	<b>D2858-2</b>
<b>Inspection Dwg:</b> D2858	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø .174	✓			
Ø0.400	+0.005/-0.000	Ø .402	✓			
R0.125	+/-0.010	R .125	✓			
0.328	+/-0.010	.330	✓			
0.820	+/-0.005	.821	✓			
1.476	+/-0.010	1.479	✓			
0.342	+/-0.010	.345	✓			
0.875	+/-0.010	.872	✓			
1.56	+/-0.030	1.56	✓			
0.147	+/-0.010	.147	✓			
0.717	+/-0.010	.717	✓			
0.697	+/-0.010	.695	✓			
0.229	+/-0.010	.235	✓			
R0.125	+/-0.010	R .125	✓			
R0.063	+/-0.010	R .063	✓			
0.063	+/-0.010	.063	✓			
0.126	+/-0.010	.126	✓			
0.630	+/-0.010	.630	✓			
R0.354	+/-0.010	R .354	✓			
0.965	+/-0.010	.964	✓			
Ø0.166	+0.005/-0.000	Ø .167	✓			

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>
<b>Date:</b>	<b>Date:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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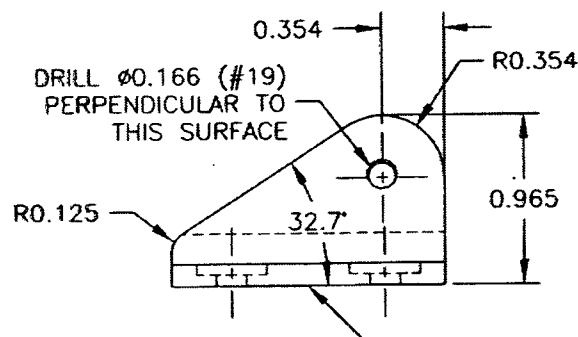
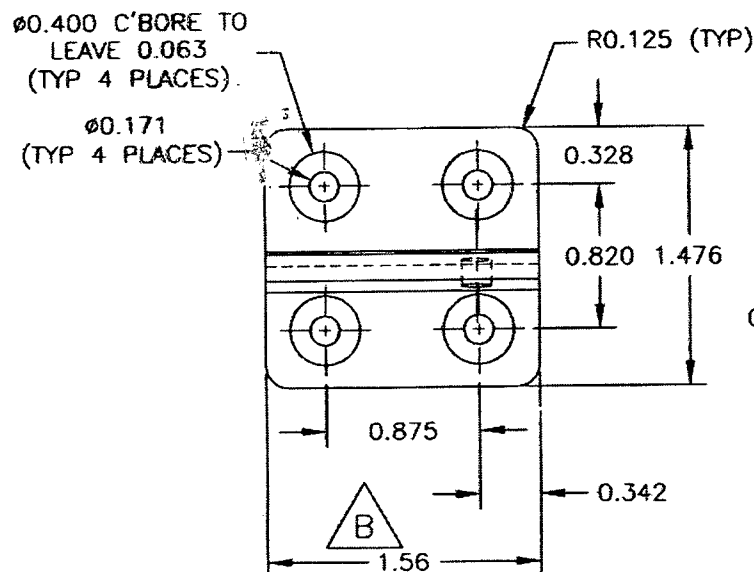
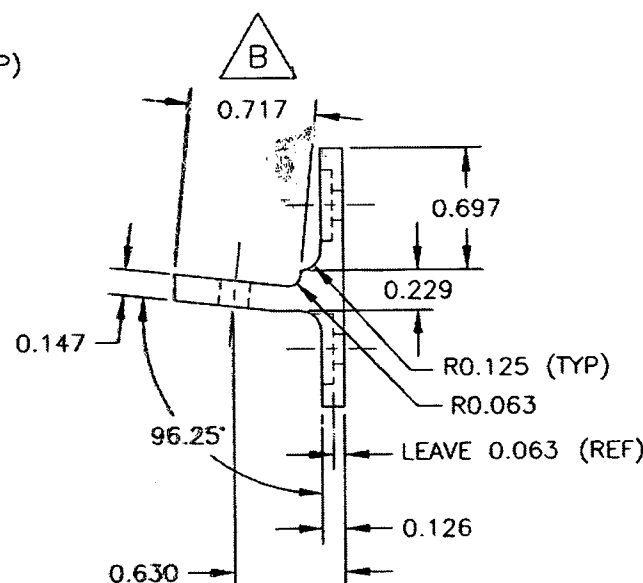
**NOTE:** Date & initial all entries

**DART**



RELEASED  
99.03.03 KE

DESIGN	LE	DRAWN BY	KE	DART AEROSPACE LTD NAWESBURY, ONTARIO, CANADA	
CHECKED	U	APPROVED	#	DRAWING NO.	D2858
DATE	99.02.28	TITLE	HINGE BRACKET	REV. B	SHEET 1 OF 1
A	98.12.14	NEW ISSUE		SCALE	1:1
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559			



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AGREEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55063  
*BP10-105*

ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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